

Work Order ID 64048

Tuesday, November 23, 2010 3:26:38 PM



Page 1

Item ID: D2327-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer Bushing

Start Date: 11/23/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: 10/11/23 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2327	Rev D

100 Hardinge CNC LATHE SMALL 0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn per Folio FA232 and Dwg D2327 ☐ Debur

SA 10/11/25

21 *Ø*

110 QC2- Inspect parts off machine FAI/FAIB 0.00



QC

Memo

0.00

Quality Control

SA 10/11/25

21 *Ø*

120 QC8- Inspect parts - second check 0.00



QC

Memo

0.00

Quality Control

B.A 10/11/25

21 *Ø*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: Pack 2

0.00



Packaging

Memo

0.00

Packaging

*****STOCK IN BASKET CELL*****

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/20 EL

10/11/20 MF

10-11-25

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NOTE: Date & initial all entries

Picklist Print

Tuesday, November 23, 2010 3:26:43 PM

Page 1

Work Order ID: 64048



Parent Item: D2327-3



Parent Item Name: Spacer Bushing

Start Date: 11/23/2010

Required Date: 11/30/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP F05.11.02 Removed 303 SS KJ/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375 		Purchased	No			100	f	36.8085	0.1563	3.290526			
304 ROUND BAR 0.375												10/11/25	

Location	Loc Qty	Loc Code
MAT	31.4685	
111323	0	
114467	5.1	
114676	1.1	
115180	1.7	
115334	23.5685	
MAT029	5.34	
113325	3.85	
114356	1.49	

3.304

W/O:		WORK ORDER CHANGES					
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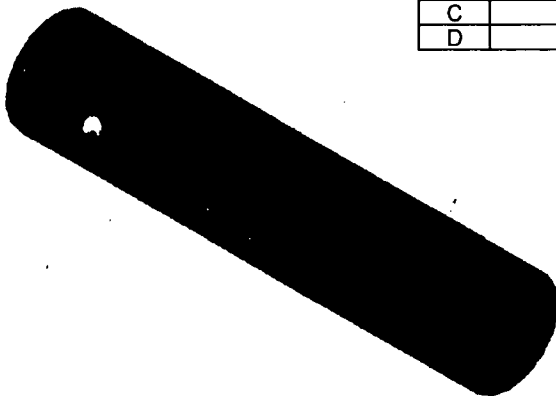
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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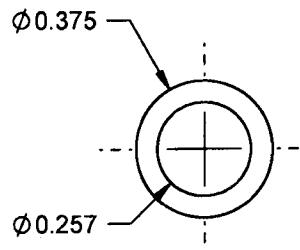
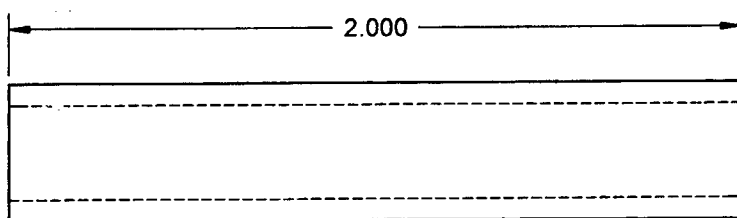
DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED LE	APPROVED CH	DRAWING NO. D2327
DATE 06.10.12		REV. D SHEET 1 OF 1
TITLE SPACER BUSHING		SCALE 2:1
REV	DATE	DESCRIPTION
A	94.12.17	NEW ISSUE
B	95.12.06	LENGTH CHANGE
C	03.05.13	303 SS SPEC ADDED
D	06.10.12	REMOVE 303 SS MATERIAL



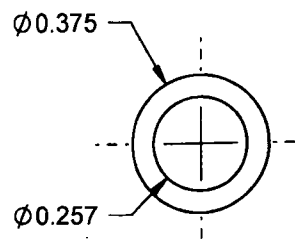
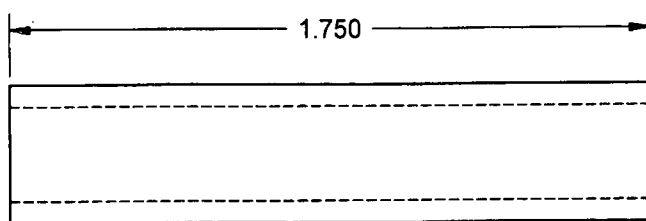
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **64096**

RELEASED

06.11.14



D2327-1 SPACER BUSHING



D2327-3 SPACER BUSHING

NOTES:

- 1) MATERIAL: AISI 304/316 SS, $\phi 0.375$, 0.065 WALL SEAMLESS ROUND TUBING
(REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



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